

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

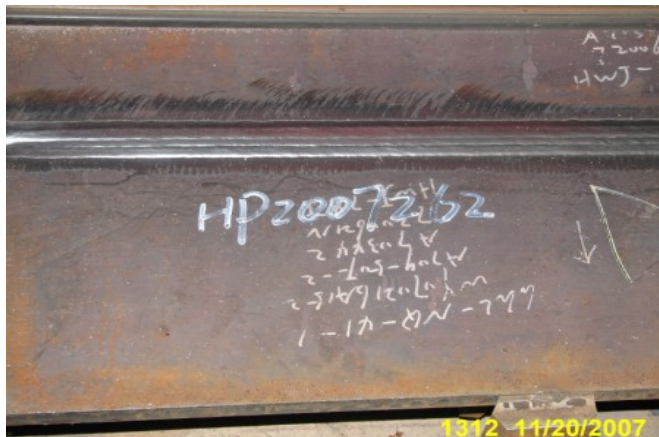
Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000937**Date Inspected:** 20-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** HP2007262**Summary of Items Observed:**

CalTrans Quality Assurance (QA) Inspector was on site at ZPMC Welding Lab to observe the welding of the Procedure Qualification Record (PQR) test plate HP2007262. PQR HP 2007262 is a multiple pass groove weld test coupon welding in the 1G position using the submerged arc welding (SAW) process. Filler metal specification AWS A5.17 and classification EM12K, electrode diameter 4.8 mm. Test plates were 26 mm thick with a 10 mm back up bar in a single V-groove butt-joint fit up. Welding was performed per AWS D1.5 2002, Section 5.13 Production Procedure WPS. Welding was performed by Xing Ji Zhan. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Huang Wei and Bureau Veritas Inspector Mr. Arbin Huang were observed monitoring welding activities at the workstation. The welding on the test coupon was completed and appeared to be in compliance with the contract documents. QA Inspector issued lot number L30-138-07.



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan
----------------------	---------------

Quality Assurance Inspector

Reviewed By:	Cuellar,Robert
---------------------	----------------

QA Reviewer
